

Work Order ID 111459

111459

Page 1

January-15-14 1:10:53 PM

Item ID: D412-758-015

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gps Receiver Gimbal Mount

Start Date: 1/15/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/15/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 1-01-16

Tooling:

Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D412-758

D

100

0.00

100

DOCUMENT CONTROL

14-1-30 DAS 6 1-39

2

ML2

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-758-015 CHG002

110

Pick Kit

0.00

110

Packaging

Memo

0.00

2

DAS 33 14-01-29 9-89

Packaging

115

QC4- 100% Inspect kits for completeness

0.00

115

QC

Memo

0.00

Quality Control

14-1-30 DAS 6 8-89

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Page 2

Item ID: D412-758-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gps Receiver Gimbal Mount

Start Date: 1/15/14 Start Qty: 1.00

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Cust Item ID:

Required Date: 1/15/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-758-015								
	Location: <u>032</u>								
	PPP Rev: _____								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

(12) 14-01-30

MLJ 14-02-04

(H) 14-01-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 111459

Parent Item: D412-758-015

Start Date: 1/15/14

Required Date: 1/15/14

Parent Item Name: Gps Receiver Gimbal Mount

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.06.21 new issue DD verified by:EC
DD VERF:JLM

IPP REV:B 12.10.24 ECN 12-669

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN525-10R9 Screw DAS 6 9-89		Purchased	No			110	Each	200.0000	3	36		DAS 33 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST344		200							
				m127703		200				127703			
D3531-041 Top Mounted Gps Bracket DAS 6 9-89		Manufactured	No			110	Each	7.0000	1	12		DAS 33 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST228		7							
				105800		4				105800			
				109624		3							
D2464 Seal (per foot) DAS 6 9-89		Manufactured	No			110	f	107.0000	1.05	2		DAS 33 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST403		107							
				83543		107				83543			
D3525-1 Placard DAS 6 9-89		Manufactured	No			110	Each	11.0000	1	12		DAS 33 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST054		11							
				103809		11				103809			
D3645-1 Washer DAS 6 9-89		Manufactured	No			110	Each	67.0000	4	48		DAS 33 9-89	14-01-29
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST060		67							
				95256		67				95256			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Design									
Doc/Data									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 111459

Parent Item: D412-758-015

Parent Item Name: Gps Receiver Gimbal Mount

Start Date: 1/15/14

Required Date: 1/15/14

Start Qty: 1.00

Required Qty: 1.00

AN525-10R10
Screw

Purchased

No

110 Each 197.0000

4 8 DAS
33
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST344

197

M126175

197

126175

NAS1149DN632J

Purchased

No

110 Each 350.0000

4 8 DAS
33
9-89

Washer
DAS
6
9-89

Location

Loc Qty

Loc Code

ST293

350

M126084

250

M127255

100

126084

NAS1149D0363J

Purchased

No

110 Each 3,352.0000

7 14 DAS
33
9-89

Washer
DAS
6
9-89

Location

Loc Qty

Loc Code

GA

78

124392

78

ST510a

3274

m126319

2074

m127813

1200

126319

MS21042L06

Purchased

No

110 Each 402.0000

4 8 DAS
33
9-89

Nut
DAS
6
9-89

Location

Loc Qty

Loc Code

ST314

402

m126474

2

m127304

200

m127831

200

127304

MS24693.S29

SCREW

Purchased

No

110 Each 98.0000

4 8 DAS
33
9-89

Location

Loc Qty

Loc Code

ST301

98

m126400

98

126400

DAS
6
9-89

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Shop Packet Print

Page 2

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 3

Work Order ID: 111459

Parent Item: D412-758-015

Start Date: 1/15/14

Required Date: 1/15/14

Parent Item Name: Gps Receiver Gimbal Mount

Start Qty: 1.00

Required Qty: 1.00

RAM-B-201U-A

Purchased

No

110

Each

8.0000

2

24

DAS
33
9-89

SOCKET ARM, 1.75"

DAS
6
9-89

Location

Loc Qty

Loc Code

ST391

8

m126477

8

126477

DAS
33
9-89

RAM-B-202U

Purchased

No

110

Each

8.0000

2

24

DAS
33
9-89

Round Plate Mount, Single 1" Ball

DAS
6
9-89

Location

Loc Qty

Loc Code

ST391

8

m126477

8

126477

DAS
33
9-89

RAM-B-217U

Purchased

No

110

Each

8.0000

1

2

DAS
33
9-89

ROUND PLATE MOUNT, DUAL 1" BALL

DAS
6
9-89

Location

Loc Qty

Loc Code

ST391

8

m126315

1

m126477

1

m126838

5

m127321

1

126838

DAS
33
9-89

MS21042L3

Purchased

No

110

Each

5,627.0000

3

36

DAS
33
9-89

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

ST506

962

123900

962

ST509

4665

M127304

1000

M127410

3000

M127831

665

127304

DAS
33
9-89

1401-29

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Page 3

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Large Fab ☐	Composite ☐	Supplier ☐																

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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14-130

5.0 PARTS LIST

QTY -011	QTY -013	QTY -015	Part Number	Description
X			D412-758-011	Bottom Mounted GPS Receiver Gimbal Mount
	X		D412-758-013	Top Mounted GPS Receiver Gimbal Mount
		X	D412-758-015	GPSMAP Top Mounted GPS Receiver Gimbal Mount
1			D3514-041	Bottom Mounted Gimbal Assembly
	1		D3514-043	Top Mounted Gimbal Assembly
			D3531-041	Bracket Assy.
	2		D2464-0066	Neoprene Seal
1	1		D3525-1	Placard
1			D3527-1	Support Arm
1			D3530-1	Base Plate
1			D3530-3	Mounting Plate
1	1		D3534-1	Doubler
	4		D3645-1	Washer
			AN525-10R9	Screw
	4		AN525-10R10	Screw
3			AN526-632R7	Screw (or MS35206-229)
3			NAS1149DN632J	Washer (Alternate p/n AN960JD6)
2	4		NAS1149D0363J	Washer (Alternate p/n AN960JD10)
3			MS21042L06	Nut
1			MS21042L3	Nut
4	4		MS24693-S27	Screw
1			MS27039-1-09	Screw
			MS24693-S29	Screw
			RAM-B-201U-A	Socket Arm, 1.75"
			RAM-B-202U	Round Plate Mount, Single 1" Ball
			RAM-B-217U	Round Plate Mount, Dual 1" Ball

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Revision: D
Date: 12.08.10